: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Qty:

Wednesday, 5/16/2007 8:13:41 AM

Kim Johnston

**Process Sheet** 

stomer

: CU-DAR001 Dart Helicopters Services

Job Number

32380

**Estimate Number** P.O. Number

This Issue

Prsht Rev.

First Issue

Previous Run

: 10834

: 31251

Alu: : 5/16/2007

MACHINED PARTS Type

**Drawing Name** 

Part Number

**Drawing Number** Project Number

**Drawing Revision** 

Material **Due Date** 

: C AU:

: N/A

: D29332

. D2933 REV C

: 6/6/2007

Um:

Each

Written By

Checked & Approved By

Comment

Est: B 00.06.26

New DWG rev (mpp 2069) EC

Est Rev:C As per Rev C 07-03-19 JLM

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

2.0

D6101001

7075-T7351.2X6X6.25



Comment: Qty.:

1.0000 Each(s)/Unit

Total: 16.0000 Each(s)

Issue material from stock: 7075-T7351 QQ-A-250/12

Cut Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length Batch No: Bas345

HAAS1

HAAS CNC VERTICAL MACHINING #1









1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

5-Deburr

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

7/06/67

16

wednesday, 5/16/2007 8:13:41 AM Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 32380

Part Number: D29332

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK

Comment: SECOND CHECK

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SPRAY PAINTING

7.0



P/0: 4056 4105 CZ67/04/03 D



Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE

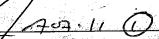
8.0

QC14



9.0

INSPECT SPRAY PAINT





Comment: INSPECT SPRAY PAINT

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



10.0

QC21

Comment: FINAL INSPECTION/W/O RELEASE



Job Completion



W A.R.12

DART AEROSPACE LTD	Work Order:	37380
Description: 206 C. Lill		2600
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		
TOPOCHOLI DWG. D2000 Nev. C		Page 1 of 1

			Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	1	2	, 3	4	Ву	Date
Α	0.100	0.140		119	119	~ 119	114		
В	0.100	0.140		119	1/20		+ 4.7	<del>  </del>	
С	0.100	0.140		124	120	120	113		
D	0.210	0.230		222	-221	-120	.119	ļl.	· · · · · · · · · · · · · · · · · · ·
E	1.245	1.255		1.256	1.250	221	.221		
F	1.245	1.255		1.250	1.250	1.320	1.250		
G	2.495	2.505		2.500	2.500	1.250	1.250		
H	0.510	0.515		0.511		2.500	2.500		
ı	1.572	1.582		1517		0.511	6571		
J	2.495	2.505		3.200		7577	1.577		
K	0.257	0.262	<del></del>		3.200	2.499	2.500		
L	0.312	0.317	<del></del>	.359	<u>329</u>	.259	.259		
М	0.235	0.240		315	315	.315	.315		
N	0.100	0.140		0.232	6.232	0.239	0.239	2	
0	0.540	0.560	<del> </del>	120	./20	.119	. 119		
Р	0.490	0.510	<del> </del>	-549	.550	.550	.550		
Q	3.715	3.725		3.719	SOC	SOC	.550 .501 3.720 2.490		
R	2.470	2.510			3.719	3,720	3.7à0		
S	0.240	0.270			2490	2.490	2.490		
T	0.100	0.180		.25a	351	.250	_aso		
Ü	1.625	1.635		140	140	.140	.)40		<del></del> -
$\overline{v}$	1.362	1.372		1.630	/630	1.630	1.636		
Ň	0.316	0.321		1.367	1.367	1.367	1.367		
$\frac{x}{x}$	1.125	1.145		.320	320	.320	320		
Ŷ	1.565	1.585	- Extended to the same	1.137	1.137	1.136	1./37		
<del>z</del>	0.178	0.198	D18695-A/B	1.576	1.576	1.576	7.576		
A	0.170	0.196		.188	188	.188	-188		<del></del>
В									
<del>c</del> +								<del></del>	
D									
E									
F								<del></del>	
G									
H	<del></del>								
		pt/Rejec							

	<b>f</b>	
Measured by:		
	Audited b	V Con //
Date: 07/05/27/	- Aladica D	
Date. 0 +105 18 + / 2	7 106 0 1 Date	
	- Fl06/03 Date	1 DAMAINA
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Rev	Date	Change		
Α	200 1.09	New Issue	Revised by	Approved
			RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	b.A	
è		La training to violote O	KJ/JLM A	all

DART AEROSPACE LTD	Work Order:	32380
	·	
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Walter Commence of the Commenc		
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on his			Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	1	2	、 3	4	Ву	Date
Α	0.100	0.140		121	122	121	· 120		
В	0.100	0.140		120	.126	-120	119		
С	0.100	0.140		191	.)19	.130	180	<u> </u>	
D	0.210	0.230		.221	-221	<u>:83)</u>	321		
E	1.245	1.255		1-250	1.250	1-250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.920		·
G	2.495	2.505		2.500	2.500	2.500	2 500		
Н	0.510	0.515		0515	654	0571	0.511		
Ī	1.572	1.582		1.577	1.577	1.5++	15++		
J	2.495	2.505		2.500)	2.500	2.500	3.200		
K	0.257	0.262		-259	-259	-259	₹3.29		
L	0.312	0.317		.315	-315	-315	-315		
M	0.235	0.240		0.239	0.237	0.237	0.235		
N	0.100	0.140		. 119	.119	- 119	-120'		·
0	0.540	0.560		549	.549	.550	·220		
P	0.490	0.510		-501	. 499	.Sol	· 200		
Q	3.715	3.725		-3.720	3.720	3.720	3:420		
R	2.470	2.510		2,490	2.490	2.490	2.490		
S	0.240	0.270		250	asi	. 251	.250		
Ť	0.100	0.180		140	-140	.140	.146		
Ū	1.625	1.635		1630	1-636	/.(હ્રેગ્રે૧	1.630		
· V	1.362	1.372		1.367	1.367	1367	1.367		
W	0.316	0.321		.320	-320	-320	-320		
X	1.125	1.145		1.136	1.135	1.137	1.140		
Ŷ	1.565	1.585	₽T8695-A/B	1.575	7575	1.576	1.578		
Z	0.178	0.198		.188	-188	-188	-188		
ĀĀ,									
AB									
AC									
AD		. 4	\$-a.						
AE									
AF									
AG									
AH								<u> </u>	
.,	Acc	ept/Reje	ct						

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Date: 07/05/28	12/06/02	Date:	07/06/09	
Date: 10+1021 & 0	1 01100107			•

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	21
C	07.03.21	Revised per drawing revision C	KJ/JLM A	411

DART AEROSPACE LTD	Work Order:	32380
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
		,
Inspection Dwg: D2933 Rev. C		Page 1 of 1

				T		ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	, 3	4	Ву	Date
A	0.100	0.140		/20	3/20	, /20	,/20"		
В	0.100	0.140		120	-131	.120	116"		
С	0.100	0.140		/21	131	-119	/25"		
D	0.210	0.230		221	220	1.250	224"		
E	1.245	1.255		1.256	1.256	1.250	1250"		
F	1.245	1.255		1.250	1250	1 /·250	1.2501		
G	2.495	2.505		2.500	2.200	2.500	2,500'		
Н	0.510	0.515		0.571	0.57/	0.511	0:511		
1	1.572	1.582		1.577	1577	1.577	1.577"		
J	2.495	2.505		2.500	2.500	2.500	2,500		
K	0.257	0.262		-259	-259	259	-259		
L	0.312	0.317		35	-315	315	315		
М	0.235	0.240		0.239	6.235	0.235	0-235		
N	0.100	0.140		./20	120	-119	.119"	1	
0	0.540	0.560		.548	.550	.250	550		
Р	0.490	0.510		~ SOI/	-502	.502	\$50 504" 3 720"		
Q	3.715	3.725		3.720	3.420	3719	3.720"		
R	2.470	2.510		2490	2.490	2.490	2490		
S	0.240	0.270		.252	-050	.2 <u>5</u> 2	256"		
Т	0.100	0.180		140	146	140	-140		
U	1.625	1.635		1.630	1.630	1.630	1 630"		
V	1.362	1.372	,	1.367	1.367	1.364	1.630"		
W	0.316	0.321		320	320	320	320		
Х	1.125	1.145		1.135	1.135	1.135	1./35		
Υ	1.565	1.585	DT8695 A/B	1.575	1.575	1.575	1.575		
Z	0.178	0.198		-188	188	.188	.188		
AA									
AB									
AC									
AD	. 1						:		
AE								i.	
AF									
AG									
AH									
	Acc	ept/Reje	ct						

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Date:	07/05/20FO	1070007	Date:	07/06/09	

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	-1
C	07.03.21	Revised per drawing revision C	KJ/JLM CK	SIII

DART AEROSPACE LTD		Work Order:	32380
Description: 206 Saddle, Inboard, Right side		Part Number:	D2933-2
	·		
Inspection Dwg: D2933 Rev. C	and the second		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
A	0.100	0.140		117"	120'	.121"	1/9"		
В	0.100	0.140		117	"/22"	.122^	,/2/"		
С	0.100	0.140		125	1,125"	1/25"	1125"		
D	0.210	0.230		224"	225'	1223"	,225"		
E	1.245	1.255		1. 250	1,250	1,250	1, 250"		
F	1.245	1.255		1,250	1,250"	1,250	1 250		
G	2.495	2.505		2.500	2 500	2.500°	2.500		
Н	0.510	0,515		0839	0 51	0.871	0511		
T T	1.572	1.582		579'	1.579"	1.579'	1.579"		
J	2.495	2.505		2 500	500	2.500"	2,500		
K	0.257	0.262		B.259"	8,259	d 259	8,259		
L	0.312	0.317		0.313"	d 3/3"	Ø 3/3°	a 3/3"		
М	0.235	0.240		0.239	0-239	0.235	0.235		
N	0.100	0.140		./20"	112	.119"	(12)"		
0	0.540	0.560		1,552	1.550°	.547"	.550"	<u> </u>	
P	0.490	0.510		,504"	,505"	.504"	,505"		
Q.	3.715	3.725		3, 720"	3.720	3,720"	3,720"		
R	2.470	2.510		2 490"	2,490	2 490	2,490"		
S	0.240	0.270		256	,256"	2.5%	,255"		•
Ť	0.100	0.180		1400	140"	140"	, 140		
U	1.625	1.635		1,630	1 620	1.630	1,630		
V	1.362	1.372		1 370"	1 270"	1.370"	1370"		
w	0.316	0.321		0,319	0 319"	o. 319'	Ø 219"		
X	1.125	1.145		1.135	1.136"	132"	1.138"		
Ŷ	1.565	1.585	-DT8695 A/B	1575	1.575	1.575	1,575"		
Ż	0.178	0.198		P. 188	A.188"	A 188"	A 188		
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AB					•				
AC		<del></del>							
AD							-		
AE									
AF		<del></del>							
AG							·		
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	Date: 02	105/29/	2200152	Date:	07/06/09

Rev	Date	Change /	Revised by	Approved
A		New Issue	RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	- A
С	07.03.21	Revised per drawing revision C	KJ/JLM OK	411
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